

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008969**Date Inspected:** 06-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG side panel stiffener hold back welds and Upper Floor beam repair areas. The weld identification numbers are as follows: SP026-001-002, 006, 009, 011, SP018-001-015, SSD12-PP22-005, FB001-003-004, FB001-003-003 and FB015-001-001.

Bay 2:

This QA Inspector observed the following work in progress: FCAW welding of OBG FL2 Floor beam welds FB3008-001-004 and 022. ZPMC welders were identified as 045203 and 062438. ZPMC QC is identified as Zhu Tian Shu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

Bay 5:

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## WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress: FCAW welding OBG Bike Path Cantilever beam welds BK001-019-001 and 003. ZPMC welder was identified as 204342. ZPMC QC is identified as Li Yang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U4c-F-1.

Bay 9:

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as OBG U-rib splice and diaphragm welds. The weld identification numbers are as follows: DP3048-001-013, 014, DP3066-001-040, 050 and 059.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation between QA and QC occurred this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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